Each

Dart Aerospace Ltd. Tuesday, 12/5/2006 8:02:03 AM Kim Johnston User: Process Sheet : PLATE **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 29751 **Estimate Number** : 10425 **Part Number** : D32191 A) (A P.O. Number S.O. No. : 1) 1/4 . D3219 REV A **Drawing Number** : 12/5/2006 This Issue : N/A Project Number : NC Prsht Rev. · NA Type : SMALL /MED FAB **Drawing Revision** First Issue :NIA : 29235 Material **Previous Run** : 12/23/2006 40 Um: **Due Date** Qty: Written By Checked & Approved By New issue KJ/JLM Comment ESR B 06.05.25 Waterjet EC **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 6061-T6 .125 Sheet M6061T6S125 1.0 Comment: Qty.: 0.1012 sf(s)/Unit Total: 4.0488 sf(s) 6061-T6 .125 Sheet To be made in multiples of 4 Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: M102272 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3219 Dwg Rev:\_\_A M 06 12 11 Prog Rev:\_\_\_ INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMAL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary.



## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHAN	IGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·							
Part No	);	PAR #: Fault Category:	NCR: Y	es No DC	A: <u>£</u>	☑ Date: ౖ	12/22
			Q	A: N/C Close	ed:	Date: _	

NCR:			WORK ORD	ER NON-CONFORMANO	CE (NCR)	NCR)							
DATE S		Description of NC		Corrective Action Section B		Verification	Approval	A					
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector					

NOTE: Date & initial all entries

Tuesday, 12/5/2006 8:02:03 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: PLATE Customer: CU-DAR001 Dart Helicopters Services Part Number: D32191 Job Number: 29751 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE W Xe12-22 Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:			ER NON-CONFORMANO	CE (NCR)	,			
		Description of NC	Corrective Action Section B			Varification	Ammuouni	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
						,		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29751
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST							
		X First Arti			otype		
Drawing	Toleranc	Actual	Accept	Reject	Method of Inspection	Cor	nments
Dimension		Dimension			mspection		
Ø0.316	+0.005/-0.0	V . J	1		VECN		
2.293	+/-0.005	2.297	<i></i>		VerN		
2.965	+/-0.010	2.765	<b></b>		verN		··
0.566	+/-0.010	0.567	<b>√</b>		VerN		
0.375	+/-0.010	0.372	$\checkmark$		VerN	· · · · · · · · · · · · · · · · · · ·	
R0.125	+/-0.010	RO. 125	$\sqrt{}$		Very		
0.125	+/-0.010	0.121	V		Vern		
13.9	+/-0.010		$\sqrt{}$		Angle Meter		
_		,					
							•
							-
				l	L		4
Measured by:	m/m1	Audited by:			Prototype App	roval:	N/A
Date:	06/2/1	Date:	06:12.	12		Date:	N/A

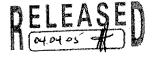
Measured by:	ml.ml	Audited by:		Prototype Approval:	N/A
Date:	06 12 11	Date:	06:12:12	Date:	N/A
	00 70 1.	L			

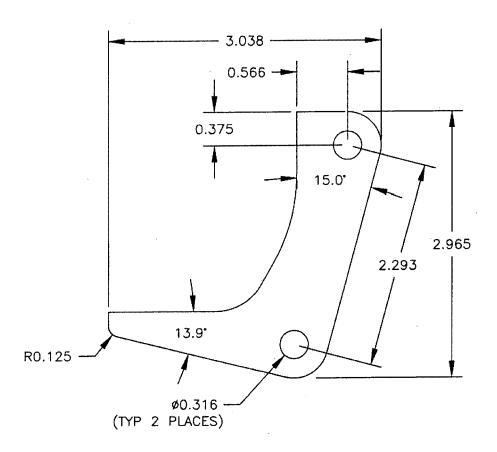
Rev	Date	Change	Revised	by∧	Approv#d
Α	04.04.19	New Issue	KJ/JLM	XX	\(\mathref{J}_1\)





DESIG	N A	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA	
CHEC	KED ,	APPROVED,	DRAWING NO.	REV. A
	#	4	D3219	SHEET 1 OF 1
DATE		<u> </u>	TITLE	SCALE
03.1	10.10		PLATE	1:1
A		03.10.10	NEW ISSUE	





## D3219-1 PLATE

1) MACHINE PER DWG FILE "D3219-1.SLDPRT"

2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)

(REF DART SPEC M6061T6S.125)

3) FINISH: NONE

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

170

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.